

Work Order ID 86349

86349

Page 1

Item ID: D2345

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lock Channel

Start Date: 27/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/28

Tooling:

Date:

Run # Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2345

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2345 Dwg Rev: A Prog Rev: A 2-

Debur if necessary

304 . 050

24 0 Jm 12-6-28

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

24 0 Jm 12-6-28

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Scrubbed

outs
(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

June-27-12 3:21:17 PM

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20

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					24	Ø		FF 12-07-09
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140		0.00							
140	NC BRAKE					24	Ø		FF 12-07-09
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D2345 using DT8241								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

counts
(24)

W/O:		WORK ORDER CHANGES					
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June-27-12 3:21:17 PM

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Page 3

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: **GA**

0.00

160

Packaging

Memo

0.00

Packaging

24

12-7-11 SP

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

OK 12/7/12

12-07-11

W/O:		WORK ORDER CHANGES					
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Picklist Print

June-27-12 3:21:21 PM

Page 1

Work Order ID: 86349

86349

Parent Item: D2345

D2345

Parent Item Name: Lock Channel

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPPRevB99.05.31Re-formatDM
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	95.8149	0.0528	1.111579			

M304S18GA

304/316 .050 Sheet

**

Jm 12-6-28

Location

Loc Qty

Loc Code

MAT020

95.814947

120604

8.66421

121626

2.65

121660

84.500737

121192

121192

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Dart Aerospace Ltd

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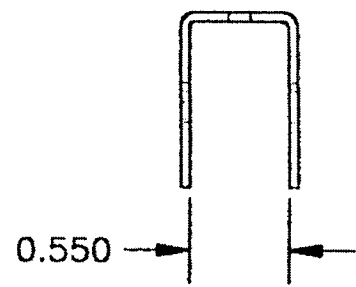
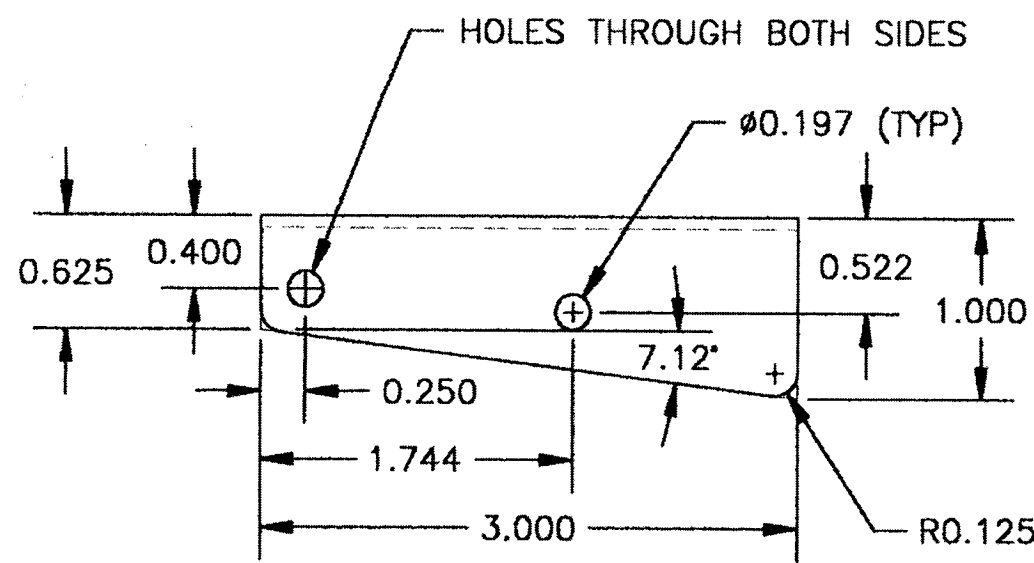
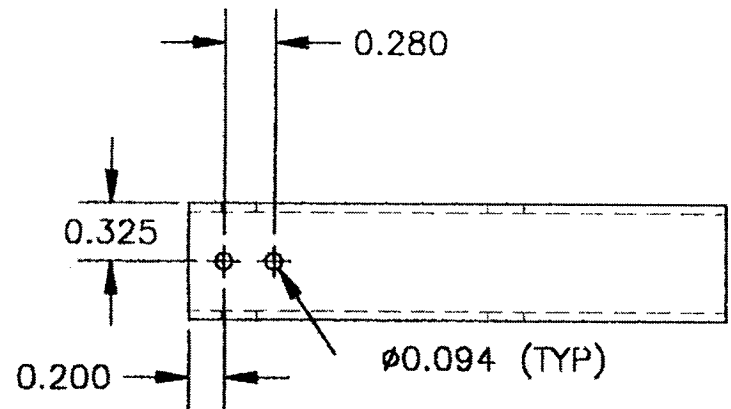


RELEASED
94602 LE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86349 MW

12/06/28

DESIGN	B WILLIAMS	DRAWN BY	B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED		APPROVED		DRAWING NO. D2345
DATE	95:02:21	TITLE	LOCK CHANNEL	REV. A
		SCALE	1:1	SHEET 1 OF 2



MATERIAL: 304/316 SS 0.050 THICK
BEND RADIUS: 0.032

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

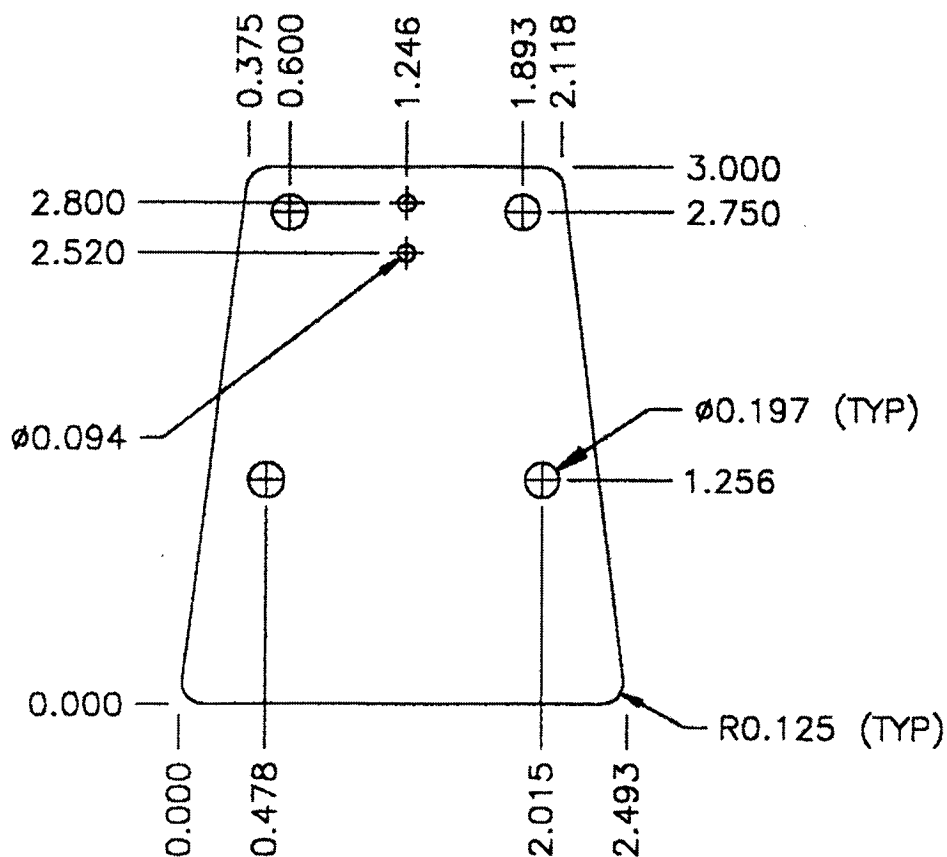
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DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	D2345	SHEET 2 OF 2
DATE	TITLE	SCALE	
95:02:21	LOCK CHANNEL	1:1	

RELEASED
94.06.02 KE



D2345 FLAT PATTERN
MATERIAL: 304/316 SS 0.050 THICK

26349

Dart Aerospace Ltd

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